

Date: Wednesday, 2/20/2008 4:20:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACERS (1/4 THICK)
Job Number : 37521	
Estimate Number : 10247	
P.O. Number :	Part Number : D2022101
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2022 REV. --
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : --
Previous Run : 33985	Material :
Written By :	Due Date : 3/20/2008 Qty: 160 Um: Each
Checked & Approved By : <u>JF 08/02/21</u>	
Comment : Est D 02.03.07 Now made in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total : 5.2584 f(s)
 6061T6 Round Bar .750"
 Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
 (M6061T6R0.750 Batch: M103857

J.F. 08/02/23 (180)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 1- Note: .257(F) Dia drill
 2-Turn Blank as per FolioFA206
 3-Tumble & deburr any sharp edges as per dwg

J.F. 08/02/23 (180)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/02/23 (180)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/02/24

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 5T9

AS 08/02/25 (180)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (1/4 THICK)

Job Number: 37521

Part Number: D2022101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



180

Comment: FINAL INSPECTION/W/O RELEASE

2008/2/25

Job Completion



2008/2/25 180

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

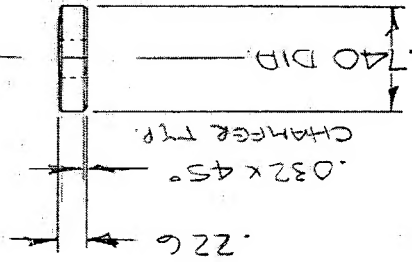
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED 970114 BCU

DRILL F' (.257) DIA. IN - 101
DRILL P (.323) DIA. IN - 103

02022-101
02022-103



MT'L: ALUMINUM 6061-T6 (00-D-225/8)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
UNCONTROLLED COPY
SUBJECT TO NOTICE
WITHOUT ORDER
WORK ORDER
NO. 37521

REVISION	DRAWN	APPROVED	DESCRIPTION	OF	CHANGE

REPORT ALL DISCREPANCIES - DO NOT SCALE					
1. DIMENSIONS AND IN REVISIONS 2. SURFACE REQUIREMENTS - SEE 1.1 3. FINISHES - SEE 1.2 4. MATERIALS - SEE 1.3 5. TOLERANCES - SEE 1.4 6. WEIGHTS - SEE 1.5 7. DIMENSIONS - SEE 1.6 8. SURFACE REQUIREMENTS - SEE 1.7 9. FINISHES - SEE 1.8 10. MATERIALS - SEE 1.9 11. TOLERANCES - SEE 1.10 12. WEIGHTS - SEE 1.11 13. DIMENSIONS - SEE 1.12 14. SURFACE REQUIREMENTS - SEE 1.13 15. FINISHES - SEE 1.14 16. MATERIALS - SEE 1.15 17. TOLERANCES - SEE 1.16 18. WEIGHTS - SEE 1.17 19. DIMENSIONS - SEE 1.18 20. SURFACE REQUIREMENTS - SEE 1.19 21. FINISHES - SEE 1.20 22. MATERIALS - SEE 1.21 23. TOLERANCES - SEE 1.22 24. WEIGHTS - SEE 1.23 25. DIMENSIONS - SEE 1.24 26. SURFACE REQUIREMENTS - SEE 1.25 27. FINISHES - SEE 1.26 28. MATERIALS - SEE 1.27 29. TOLERANCES - SEE 1.28 30. WEIGHTS - SEE 1.29 31. DIMENSIONS - SEE 1.30 32. SURFACE REQUIREMENTS - SEE 1.31 33. FINISHES - SEE 1.32 34. MATERIALS - SEE 1.33 35. TOLERANCES - SEE 1.34 36. WEIGHTS - SEE 1.35 37. DIMENSIONS - SEE 1.36 38. 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